93238

Page 1

November-15-12 10:2	1:45 AM		, 		/ . 1()						
Item ID: 646.3 Revision ID: Item Name: Shim	910			Accept	*N900	<u>040</u>	100)* s	Setup Star Stop	1 7	S1* S2*
Start Date: 11/15 Required Date: 12/07 Reference:		eq'd Qty: 80.00	*80 *80		Cust Item I Customer:	ID:		_			
Approvals: Pro	cess Plan:	MLJ	Date: 17-11-	•	D	ate:		ŀ	Run Star Stoj	" \	R1*
QC:	·		Date:	SPC (Y/N):	D	ate:				*N	R2*
Sequence ID/ Work Center ID	-	peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	n Nbr									
646.3900	N/C										
110				0.00				\sim			
110 Waterjet		Мето		0.00				(Q)			[6-11-7]
FLOW CNC Waterjet	£L . GÔ	1-Cut as per l Dwg Rev: <u>N</u> Prog Rev:	10								
		2-Deburr if n	ecessary								
120	QC	C2- Inspect parts off ma	achine FAI/FAIB	0.00				(97)		_	
120 QC Quality Control		Memo		0.00				(0)		. _. V	312-11-3,7

										DQA:	Date:				
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UPDATE	·					
										QA Closed:	Date:				
Work Orde	er:					DISPOSITION			AGAINST D	DEPARTMENT/	PROCESS				
Part N	٠ ا					Rework Scrap		1	Skid-tube Crosstube Small Fab	⊣	Water Jet d. Eng. Coor.	Engineering Quality			
NCR I	No.					Use-as-is Work Order Update		inern	noforming Finishing Large Fab Composite	Rec/Stor	e/Packaging Supplier	Other			
Root					Descr	iption of work order update		nitial	Action	Sign &					
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector			
oc/Data															
quip/Tooling															
Operator															
<i>N</i> aterial	Ш														
etup			;						·						
Other															
rocess	\blacksquare														
upplier	Н														
raining	\vdash														
Inapproved			j				FALII	T CATE	CORV						
Landi	na G					General	AUL	.i CATE	GORT						
Landi	$\overline{}$	Bending			Г	Bend	Г	Grain	Г	Ovalized		Pressure/Forced			
	-	Centre No	t Concer	atric to (_{3/5}	BOM/Route	-	Hardwa	re	Over/Under	tolorance	Temperature/Cure			
	-	Cracks	Conce		³ , –	Broken/Damaged	-	ł	on Incomplete	Part Incorred	-	Weld			
	-	Crushed/C	rimped		<u> </u>	Burrs	-	ł '	ions Incomplete/Unclear	Part Lost/Mi		Wrong Stock Pulled			
	$\overline{}$	Cuffs			—	Contamination	\vdash	Mainte	· · · · · · · · · · · · · · · · · · ·	Part Moved		J. T. O. Ig Stock Talled			
	-	Heat Treat	t		 	Contamination		Mislabe		Positioned V	/rong				
		Inspection		Tube	F	Cut Too Short		Misread	-	Power Loss/		Other			
	_	Ripples in				Drill Holes		Offset	L						
				ves in Extrusion Drawing			Out of Calibration								
	Turning Sequence Finish				1	Sequence									
		Wave/Twi	st in Tub					Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93238 November-15-12 10:21:45 AM				Page 2						
Item ID: Revision ID: Item Name:	646.3910 Shim			Accept	*N900	<u>040100</u>)* Se	tup Start Stop	*NS1 *NS2	
Start Date: Required Date: Reference:	11/15/12 12/07/12	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*		Cust Item I Customer:	D:				
Approvals:		in:	Date:	Tooling: SPC (Y/N):		ate:	Rı	Stop	*NR1 *NR2	
Sequence ID/ Work Center ID 130 *130* QC Quality Control		Operation Description QC8- Inspect parts - second check Memo		Set Up/ Run Hours 0.00 AS 15 0.00 \2 \\2 \\2 \\2 \&	Tool ID	Tool # Plan Code	Accept Qty QC CO		Reject Insp. Number Stamp	
140 *140* Outsource3 Outsource process	- Cad plate	Outsource process-Cadpl Memo Issue P/O:	ate per QSI017 4.1.9.1	0.00			****	_JL]	12-5-1	2
150		Receive & Inspect for Da	ımage & Mat'l Certs	0.00			A .			

0.00

Memo

150 Packaging

Packaging

											DQA:	Date:	• ,
NCR:	'es	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UPDATE		04.61	Data	•
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAII	NST DE	PARTMENT	/PROCESS	
Part N						Rework Scrap		Skid-tube Crosstube Machining Small Fab			Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR i	۱o.					Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Stor	re/Packaging Supplier	Other
Root					Descr	iption of work order update	T	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
oc/Data							:						
quip/Tooling													
perator								ļ					
/laterial													
etup								÷					
Other								. 4					·
rocess									+				
upplier													
raining													
Inapproved							<u> </u>						
							AUL	T CATE	GORY				
Landi	ng (Gear				General	_	_		_	_		-
		Bending			<u> </u>	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs			. [Contamination		Mainte	nance		Part Moved		-
		Heat Trea	t		· [Countersink		Mislabe	led	Г	Positioned V	Vrong	_
		Inspection	pection Strip in Tube Cut Too Short				Misread	İ		Power Loss/Surge		Other	
		Ripples in	Bend			Drill Holes	Offset						
	Torque Waves in Extrusion Drawing				Out of Calibration								
		Turning Sequence Finish				Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID 93238 November-15-12 10:21:45 AM				*932	Page (
Revision ID:	646.3910 Shim			Accept	*N900	040	100)* s	etup Start Stop	*N: *N:	S1* S2*
Start Date: Required Date: Reference:	11/15/12 12/07/12	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*		Cust Item I Customer:	D:					
Approvals:	Process Pl	lan:	Date:	Tooling:	Da	ate:		F	tun Start	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part comple	eteness to step on W/O	Set Up/ Run Hours 0.00 AS 0.00 I3- 2	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*170 *170* Packaging		Identify as per dwg & Sto Memo ***IDENTII REV***	ock Location: <u>\$</u> 1390 FY AS PER APICAL MPP	0.00 0.00 -120 BY STAMPING T	HE P# AND			/	143/2	15	99_
*180		QC21- Final Inspection	- Work Order Release	0.00					13	12/6	
QC Quality Control		Memo		0.00							N/

M 13.03,

										DQA:	Date:	* >
NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UF	PDATE	QA Closed:	Date:	•
Work Ordei	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No	0				Rework Scrap Use-as-is Work Order Update	-	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descript	tion of work order update	Ini	tial	A	ction	Sign &		<u> </u>
Cause	Date	Step	Qty	or	Non-conformance	Chie	f Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling						}		,				
Operator												
Material		1]	
Setup												
Other												
Process							~ .					
Supplier												
Training					•							
Jnapproved												
			-		F	AULT	CATE	GORY	-			
Landin	g Gear	·			General							

Bend Grain Bending Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Positioned Wrong Countersink Mislabeled Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

* Picklist Print

November-15-12 10:21:44 AM

Work Order ID:

93238

Parent Item:

646.3910

Parent Item Name:

Shim

Start Date: 11/15/12

Required Date: 12/07/12

Page 1

Start Qty: 80.00

Required Qty: 80.00

Comments:	IPP REV:A 12.12	.23 NEW ISSUE	E DD V	ERF:									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020 C1095 Blue Tempered Space	pring Steel Sheet .020	Purchased	No			110	sf	12.0000	0.03	2.5263158	8 >, B	2-11-	

											DQA:	Date	• ,
NCR: \	Yes ,	/ No				WORK ORDER NON-O	CON	NFORM	ANCE / UPD	ATE			-
											QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update Rework Skid-tube Machining Small Fab Thermoforming Finishing Large Fab Composite			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty	c	or Non-conformance	Ch	nief Eng Description			Date	Verification	QC Inspector
Doc/Data										-			
Equip/Tooling											}		
Operator													
Material													
Setup				,									
Other								Ì					
Process													
Supplier	П							1					
Training											-		
Unapproved													
						F	AUL	T CATE	GORY		•		
Landi	ng Ge	ar		General									
	В	ending				Bend					Ovalized		Pressure/Forced
	∏c	entre No	t Concer	oncentric to O/S BOM/Route			П	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged				Inspecti	on Incomplete		Part Incorre	-	Weld			
	Crushed/Crimped. Burrs				Instructi	ons Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
i	Cuffs Contamination					Mainte	nance		Part Moved	· <u>L</u>	-		
	Heat Treat Countersink				Mislabeled			Positioned V	Vrong				
	Inspection Strip in Tube Cut Too Short				Misread			Power Loss/		Other			
Ì	Ripples in Bend Drill Holes				Offset								

Out of Calibration

Out of Secuence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	93738
Description: SHim	Part Number:	41 3410
Increasing December 2011 December 2011		
Inspection Dwg: (46-346 Rev: N/C		Page 1 of 1

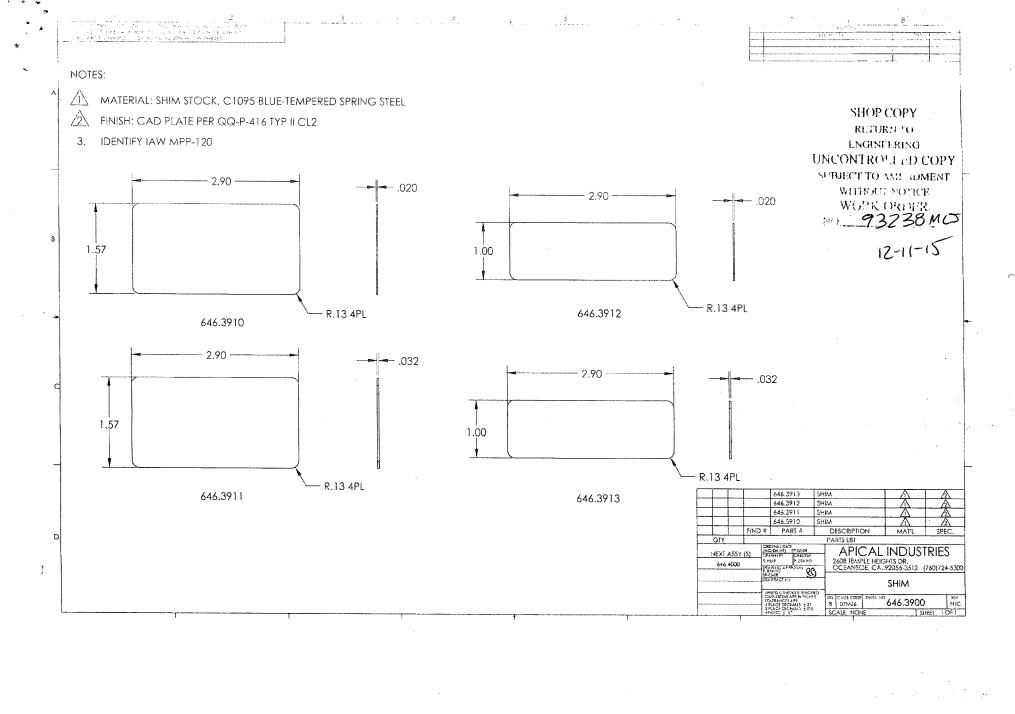
FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual	1		Maskadas	·
Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Comments
1.57	4 000	1,571	2		V BUZ	
2,90	12 (70)	2,904	a		V	
.060,	7 .008	,030	а		1/	
€.						
-						
						ų t
		977 543		·	·	
			*	sh		
		2.1				
		*				`
				,		·
						-
	e germania ya n	•				
•						
	1.12					-
			a fala 5-			7
	44. 44			· ·		
				٠,		
	*					
· · · · · · · · · · · · · · · · · · ·		1				
						•
						· · · · · · · · · · · · · · · · · · ·
*	1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1					
			- OAS			

Measured by:	B	
Date:	(2-11-27	

Audited by:	15
Date:	101)28

Preliminary Approval:	
Date:	•



CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Jan-08-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

120744

INVOICE #:

64009

CONTRACT OR

PURCHASE ORDER #

PO18582

DESCRIPTION:

SHIM

QTY

99

P/N # 646.3910

S/N # 93238

STRIP AND CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 CLEAR CLASS 2. BAKE HEAT CHART # 13-14.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:

